

Date: Monday, 3/13/2006 7:30:57 AM
 User: Kim Johnston

Process Sheet

split 8B 06/04/21

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26217 -2
 Estimate Number : 11119
 P.O. Number : N/A
 This Issue : 3/13/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : N/A
 Drawing Name : CLAMP
 Part Number : D30411
 Drawing Number : D3041 REV. A I
 Project Number : N/A
 Drawing Revision : A I
 Material : N/A
 Due Date : 3/30/2006 Qty: 40 Um: Each
 Written By : *SEE COMMENT BEPW*
 Checked & Approved By : *SEE ABOVE USER & DATE*
 Comment : Est:A 01.07.11 New Issue SM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0875 f(s)/Unit Total : 3.4986 f(s)

Lug Extrusion

(D2423)

Batch: *B23779*

J.G. 06/03/25 41

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 Extrusion: 1.250" Long

J.G. 06/03/25 41

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio FA153

PG

Issue P.O. #00000893 A 06/03/28

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Review & Inspect

06/04/11 38

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Inspect

06-04-15 38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/13/2006 7:30:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 26217

Part Number: D30411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

5AD 06/04/19

38

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-04-20

38

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask inside of 0.8120" diameter hole

DL 06/04/22

38

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SB 06/05/05

28

10.0

D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bearing

Pick:

Qty Part Number Description Batch

1 D2611

Bearing

20 B24769

8 B 25009

SB 06/05/05

28

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press D2611 bearing into lug as per Dwg D3041

2- Stake bearing into place as per Dwg D3041

SB 06/05/05

28

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-05-06

28

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST119

06/05/08 (28)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/13/2006 7:30:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 26217

Part Number: D30411

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

AD 06/05/08 (28)

Job Completion



u 06-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

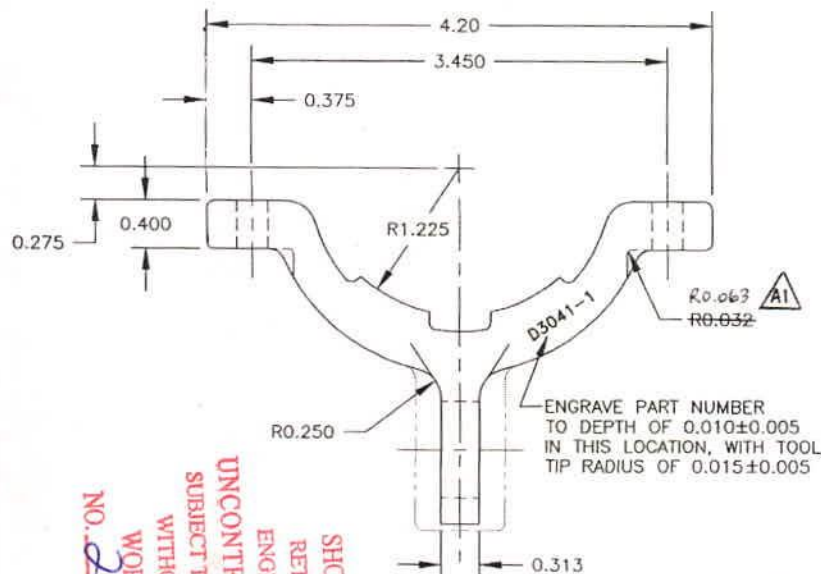
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

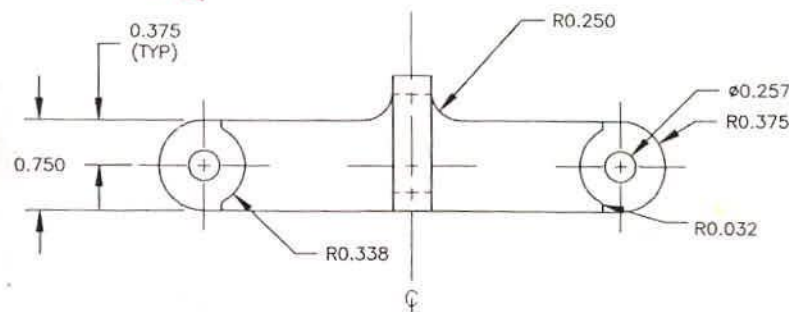
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3041-1

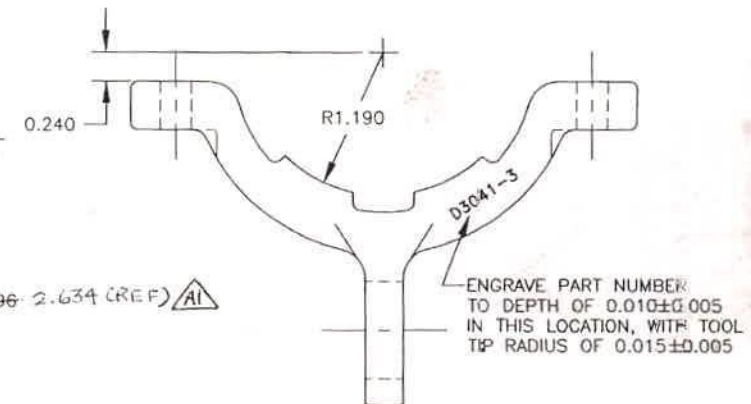


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26217



D3041-3

SAME AS D3041-1 EXCEPT AS SHOWN



RELEASED
01.07.08

UNDER REVIEW
01.07.11

D3041-1 & D3041-3 CLAMPS

- 1) MANUFACTURE FROM EXTRUSION D2423
- 2) PART IS SYMMETRIC ABOUT CENTERLINE
- 3) BREAK ALL SHARP EDGES 0.010-0.020
- 4) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 5) STAKE BEARING 4 PLACES AFTER POWDER COAT
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A		01.06.28	NEW ISSUE
DESIGN	CP	DRAWN BY	CP
CHECKED	#	APPROVED	#
DATE	01.06.28	DRAWING NO.	D3041
TITLE		CLAMP	1:1

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DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

REV. A
SHEET 1 OF 1

CHANGE TO ROUND END DETAIL
R0.063 WAS R0.032
01.09.06



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
38	D3041-1	Clamp	0893

20/4/11
MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, April 11, 2006